

Work Order ID 53803

November 18, 2009 12:45:25 PM

Deven 54258



Item ID: D3278-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacer

Start Date: 18/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *09/11/18*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3278
Deburr if necessary

☐ Dwg Rev: *C*

☐ Prog Rev: *C*

☐ 2-

*DELRIN
126*

189-11-27

EP 09/12/01

(121)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

189-11-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 80212602

*counters
(121)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/2								

NOTE: Date & initial all entries

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Item ID: D3278-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacer

Start Date: 18/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-C'sink as per dwg D3278□2-Deburr

Handwritten: 309/12/03 (120) P10?

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Handwritten: 28 on 12/03

Handwritten: 11/20

150

0.00



Identify as per dwg & Stock Location: 78

Packaging

Memo

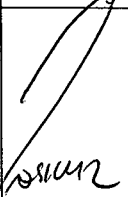
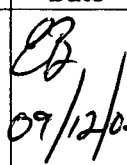
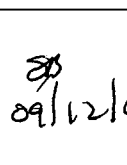
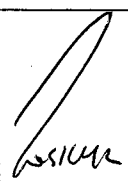
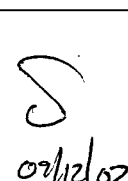
0.00

Packaging

Handwritten: 12/17 (120)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-3 PAR #: N/A Fault Category: Small fab NCR: (Yes) No DQA: 10 Date: 09.12.08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 10 Date: 08.12.11

NCR: 53803		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/2	# 130	During ismiki Dart mure in employee's hand. - cause counterside to be oval R.C. Process.		- Scrap and destroy Qty 1 No Repl/ze	 09/12/02	 09/12/03		 09/12/02

NOTE: Date & initial all entries

Work Order ID 53803

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Item ID: D3278-3

Accept

Setup Start

Revision ID: C

Stop

Item Name: Spacer

Start Date: 18/11/2009 Start Qty: 40.00

Required Date: 25/11/2009 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/07

W 09.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:45:32 PM

Page 1

Work Order ID: 53803



Parent Item: D3278-3RevC



Parent Item Name: Spacer

Start Date: 18/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MDELRINS0.125

Purchased

No

110

sf

9.3300

1.4484

4.3814



FB 9-11-07

Black Delrin Sheet .125

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

101657

104803

15607

9.33

1

4.33

4

15607

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

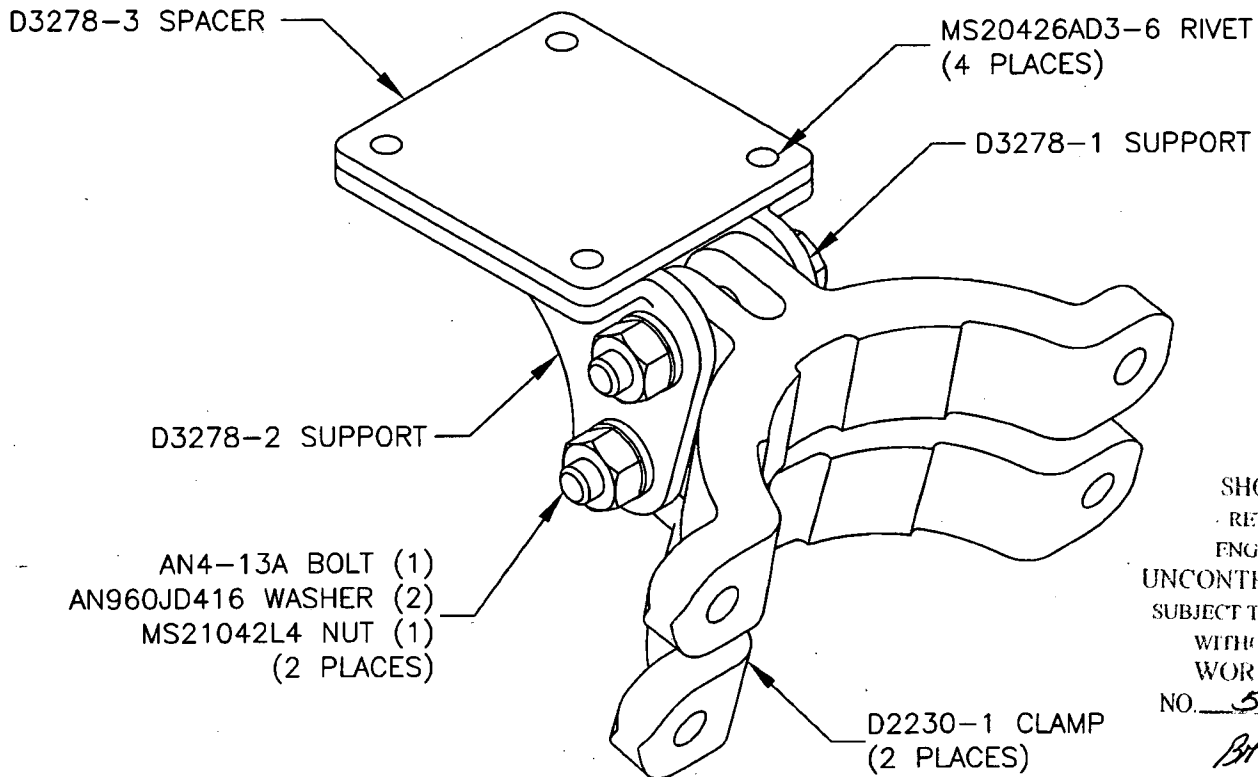
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 53803
BA 09-11-18

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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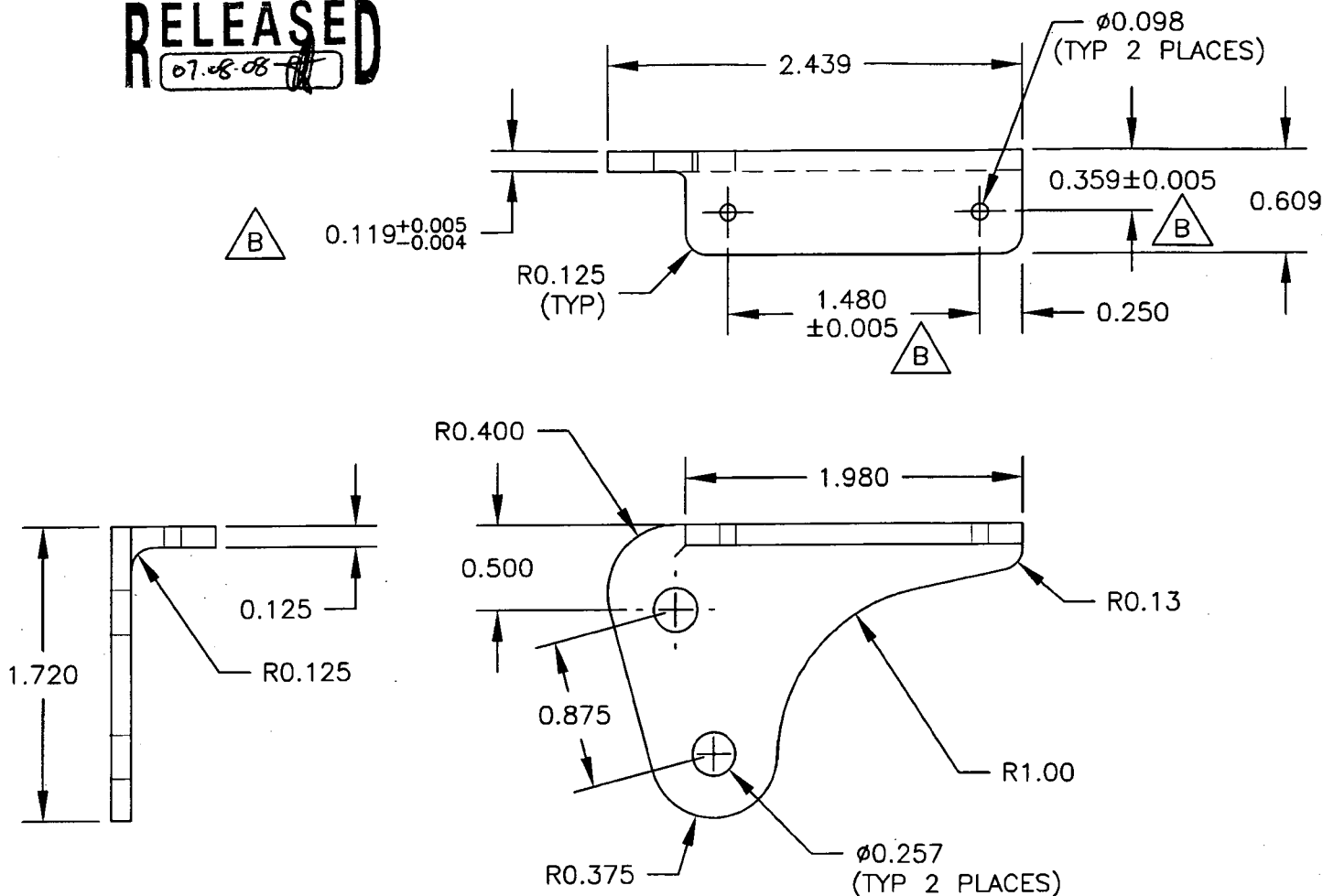
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08

W/O 53803



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

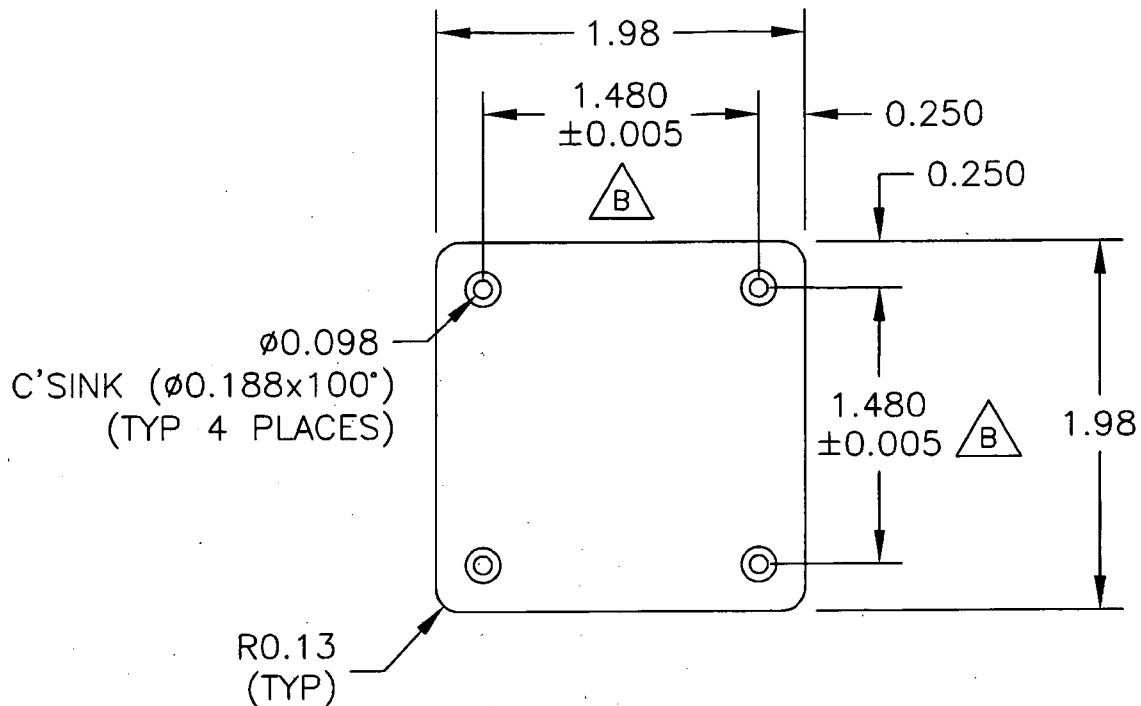
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08*w/o 53803***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-80.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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